

1. In a method of forming a container end, the steps of
 - a) forming a dome region for the upper end of such container;
 - b) forming a neck extending upwardly of the upper end and having an opening at the top of the neck defined by a lip;
 - 5 c) forming a curl on the neck lip around the opening; and
 - d) forming multiple thread lugs around and protruding outward from the neckby reforming portions of the wall of the neck into a plurality of circumferentially extending spaced apart lugs projecting outwardly from the neck in
10 predetermined alignment about the neck and at a predetermined spacing from said curl.
2. The method of claim 1, in which
step (c) forms the curl extending outward from the lip.
15
3. The method of claim 1, also including the steps of
 - e) feeding a thin strip of metal along a predetermined path;
 - f) forming disc shaped blanks from the thin strip of metal;
 - g) creating integral flexible connections between the blanks and the thin
20 strip of metal, the flexible connections extending from the outer edge of each blank to the edge of the surrounding material from which the blank is formed;
 - h) forming the blanks into cup form including an open edge;
 - i) then forming the blanks into the dome regions and continuing with
25 steps a) to d); andthen separating the dome regions from the flexible connections,
wherein steps a) to i) are performed sequentially at successive stations and
the thin metal strip is advanced from one station to the next between
the forming steps.
- 30 4. The method of claim 3, in which there are multiple sets of the successive stations arrayed along parallel paths and the steps (a) to (i) are

performed on a common metal strip which is advanced along said sets of successive stations.

5. The method of claim 3 wherein the flexible connections are formed as multiple strips connecting the periphery of the blanks to the thin metal strip.
6. A method of forming a container end comprising the steps of:
 - providing a strip of metal;
 - forming blanks in the metal strip wherein each blank is connected to the strip via a plurality of integral carrying strips between the blanks and the strip;
 - forming the blanks into cup form including an open edge;
 - forming a neck with a closed end on the cup form above the dome shaped region;
 - 15 piercing the closed end of the neck top to form a neck opening having a lip;
 - forming a curl on the neck lip to define a pour opening;
 - forming multiple thread sections around and protruding outward from the neck; and
 - 20 then severing the formed blanks from the strip.
7. The method of claim 6 comprising the further step of forming a dome shaped region in the open edge of the cup form;
8. The method of claim 6 wherein steps are performed sequentially at successive stations.
9. The method of claim 7 comprising the step of advancing the strip from one station to the next between the forming steps.
10. The method of claim 6 wherein the thread section forming step includes the steps of

reforming portions of the wall of the neck into a plurality of thread lugs extending outwardly from the neck in predetermined alignment.

11. The method of claim 6, comprising the further step of providing multiple
5 sets of successive stations arrayed along parallel paths.

12. Apparatus for forming a container end comprising
means for forming a dome region for the upper end of such container;
means for forming a neck extending upwardly of said upper end and
10 having an opening at the top of said neck defined by a lip;
means for forming a curl on said neck lip around said opening; and
means for forming multiple thread lugs around and protruding outward
from said neck by reforming portions of the wall of said neck into a plurality of
circumferentially extending spaced apart lugs projecting outwardly from said
15 neck in predetermined alignment about said neck and at a predetermined
spacing from said curl.

13. Apparatus for forming can ends comprising
means for feeding a thin strip of metal along a predetermined path,
20 means for forming disc shaped blanks from said thin metal strip,
means for forming the blanks into cup form,
means for forming a dome shaped region in said cup form,
means for forming a neck on said cup form atop said dome shaped
region, said neck having an open upper end surrounded by a lip,
25 means for forming a curl on the neck lip to define a pour opening, and
means for forming multiple thread lugs spaced apart around and
protruding outward from said neck at a predetermined spacing below said
curl.

14. The apparatus defined in claim 13, wherein said means for forming
30 thread lugs are supported along said predetermined path following said
means for forming a neck.

15. The apparatus defined in claim 13, wherein said means for forming thread lugs operates to reform portions of the wall of said neck into a plurality of thread lugs integral with and extending outwardly from said neck.

5

16. The apparatus defined in claim 13, wherein there are duplicate multiple sets of forming means arrayed along parallel lanes, and
said means for feeding a thin strip of metal is constructed and arranged to advance a common metal strip incrementally along said lanes.

10

17. The apparatus defined in claim 13, further including
a reciprocating press having a bed and ram into which said multiple sets of forming means include upper and lower cooperating tool sets mounted to define said parallel lanes of the progressive forming means and into which
15 said means for feeding a material strip is arranged to advance the material strip incrementally when the cooperating tool sets are separated during press operation.

18. The apparatus defined in claim 13, further including means for
20 discharging the completed container ends from the press, and
means for separately discharging the remains of the material strip after separation of the ends therefrom.